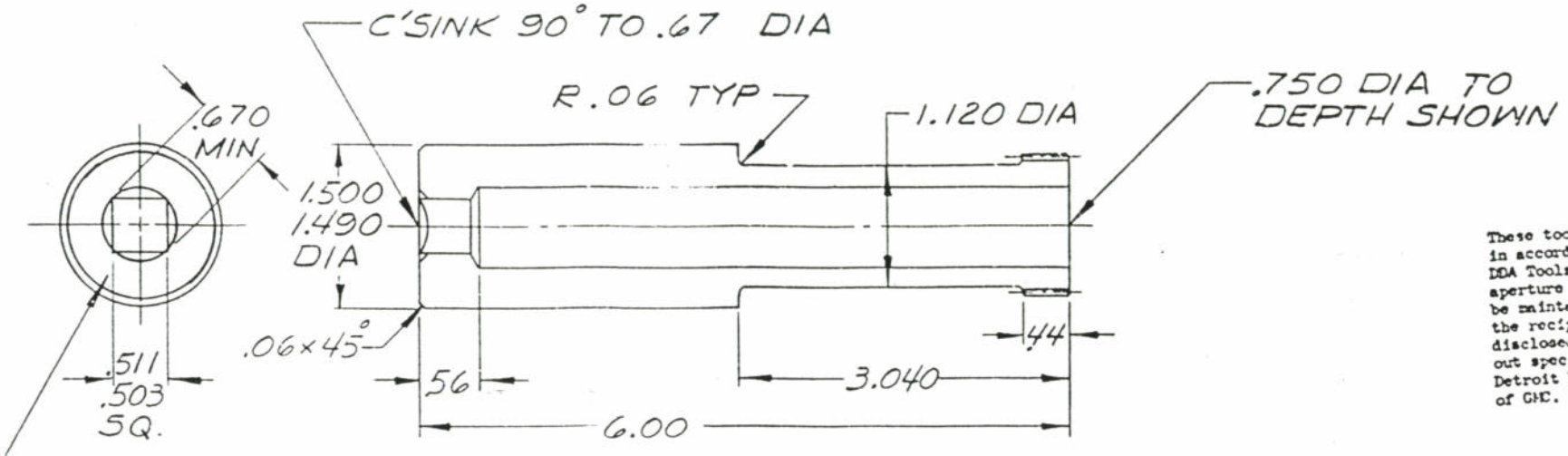
EXTERNAL SPLINE DATA	
NO. OF TEETH	40
PITCH	32/64
PRESSURE ANGLE	30°
BASE CIRCLE DIA	1.0825
MINOR DIA	1.194 MIN
FORM DIA	1.215
PITCH DIA	1.2500
MAJOR DIA	1.265 - 1.281
TOOTH TIP BREAK	.005 MAX

ARC TOOTH THICKNESS AT P.D. = .0441 - .0491
DIM. OVER TWO .0600 PINS = 1.3356 - 1.3437

REVISIONS				
MICRO FILMED	LTR	DESCRIPTION	DATE	APPROVED



(1) SAE 4130
HON - Rc 32-36

NOTES:

1. MARK AS SPECIFIED IN LOCATION SHOWN WITH 1/8 - 3/16 HIGH FIGURES THE FOLLOWING:
   a) THE NAME "ALLISON" FOLLOWED BY THE TOOL NUMBER AND LAST CHANGE LETTER.
   b) VENDOR NAME OR TRADEMARK.
2. BLACK OXIDE PER AMS 2485
3. BREAK SHARP EDGES .020 UOS

AMS 2485
SAE 4130
LOCAL SPECS. (REF)

DRAWING PRACTICE	
SURFACE TEXTURE	
SCREW THREADS	
GENERAL SPECIFICATIONS	SPEC. SUMMARY

These tool drawings are furnished in accord with the terms of the DDA Tools Release Agreement. The aperture cards or drawings are to be maintained in the custody of the recipient and shall not be disclosed to any third party without specific written consent of Detroit Diesel Allison Division of GMC.

6889894

REF - 6795984

EACH ITEM PURCHASED SEPARATELY MUST BE STAMPED OR ETCHED WITH TOOL NUMBER AND DETAIL NUMBER. IF SUITABLE OR SUFFICIENT AREA NOT AVAILABLE, ATTACH TAG.

USED ON ENGINE MODELS 250 SERIES

GEOMETRIC CHARACTERISTIC SYMBOLS

FLATNESS	PERPENDICULARITY	(M) OR MMC (MAX MATL CONDITION)
STRAIGHTNESS	PARALLELISM	(S) OR RFS (REGARDLESS OF FEATURE SIZE)
ROUNDNESS	ANGULARITY	X.XXXX BASIC DIM
CYLINDRICITY	RUNOUT	Ø DIAMETER
PROFILE OF A LINE	TRUE POSITION	-A- DATUM IDENT
PROFILE OF A SURFACE	CONCENTRICITY	
	SYMMETRY	

UNLESS OTHERWISE SPECIFIED:
ALL TRUE POSITION TOLERANCES AND RELATED DATUMS MMC.
ALL OTHER FORM AND POSITIONAL TOLERANCES AND RELATED DATUMS RFS.
SEPARATE TRUE POSITION CALLOUTS MAY BE GAGED SEPARATELY REGARDLESS OF DATUM REFERENCE.
RUNOUTS ARE CIRCULAR.

UNLESS OTHERWISE SPECIFIED	
TOL. ON ANGLES =	1°
TOL. ON 3 PLACE DECIMALS =	.010
TOL. ON 2 PLACE DECIMALS =	.02
MATL.	SEE ITEM
HEAT TREAT AND HARDNESS	SEE ITEM
SURFACE TREAT.	NOTED
INSPECTION	

APPROVALS		DATE
DRAWN	Barrett 1838	AUG 16, 74
CHECKED	R Angel, Rm	SEP 12 74
CHF. DR.	CA Brandt	SEP 12, 74
METALLURGY	—	
ENGR. 1	L A CHERRY	AUG 22 74
ENGR. 2		
ENGR. 3	E J RUDISH	SEP 5 74
FINAL	RJ HINKY	SEP 5 74
REVIEW APPROVAL		

Detroit Diesel Allison
Division of General Motors Corporation
Indianapolis Operations

TITLE: HOLDER-SPLINED, POWER TURBINE SHAFT

MODEL (FIRST USAGE)	APPLICATION: SEE SEPARATE PARTS LIST

SIZE	CODE IDENT	DWG. No.
C	73342	6889894

SCALE 1/1 SHEET

FILE COPY

FORM 852C (REV. 8-72)

FJMC